Date:

Thursday, 10/19/2006 10:46:31 AM

Chantal Lavoie

### **Process Sheet**

Customer Job Number : CU-DAR001 Dart Helicopters Services

: 29074

**Estimate Number** 

: 10518

P.O. Number This Issue

**Previous Run** 

NIM

S.O. No. : NIM : 10/19/2006

Prsht Rev. First Issue

: 28210

Written By Checked & Approved By

Comment .

: Est:B

Type

: MACHINED PARTS

**Part Number Drawing Number** Project Number

**Drawing Name** 

**Drawing Revision** Material **Due Date** 

: 1/14 : 10/19/2006

: D28063

: N/A

D2806 REV A

: BUSHING

Qty:

Each

**Additional Product** 

Job Number:



Seq. #:

Description:

1.0

M6061T6H1000

6061-T6 1" HexBar

0.4809 f(s)

KJ/JLM

Comment: Qty.: 0.0962 f(s)/Unit

6061-T6 Hex Bar 1.0"

Material: 6061-T6 (QQ-A-200/8 or QQ-A-250/11) 1.00" Hex Bar

Total:

M100720

HARDINGE

HARDINGE CNC LATHE SMALL



Comment: HARDINGE CNC LATHE SMALL

1-Turn as per Folio FA105 and Dwg D2806

2-Tumble

INSPECT PARTS AS THEY COME OFF



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

3.0

MILLING CONV

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Drill as per Dwg D2806

SECOND CHECK

5.0

QC8

Comment: SECOND CHECK

MS

6

# Dart Aerospace Ltd

W/O: WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
•								
		8						
			5					
				L l	$\bigcirc$			

Part No:	PAR #:	Fault Category:	NCR: Yes No DQA:	B Date: 06/10/2
			QA: N/C Closed:	Date:

NCR:			WORK ORD	ER NON-CONFORMAN	CE (NCR)			
		Description of NC	Corrective Action Section B			Verification	Ammanal	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspecto
		vir						

NOTE: Date & initial all entries

Date:

Thursday, 10/19/2006 10:46:32 AM

User:

Chantal Lavoie

**Process Sheet** 

Customer: CU-DAR001 Dart Helicopters Services

**Drawing Name: BUSHING** 

Job Number: 29074

Part Number: D28063

Job Number:



Seq. #:

**Machine Or Operation:** 

Description:

6.0

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

7.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSIQ



Comment: INSPECT ALODINE



8.0 PACKAGING 1



PACKAGING RESOURCE #



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:\_\_\_

206/10/19



9.0 QC21







Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



CZ06110119

Dart Ae	rospace Ltd	<b>i</b>						
W/O:			WORK ORDER	CHANGES				
DATE	STEP	PRO	OCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Category:	NCR: Yes	No DQ	A:	_ Date: _	
				QA:	N/C Close	d:	Date: _	
NCD.			<b>VORK ORDER NON-CON</b>	FORMANCE (NC	R)			

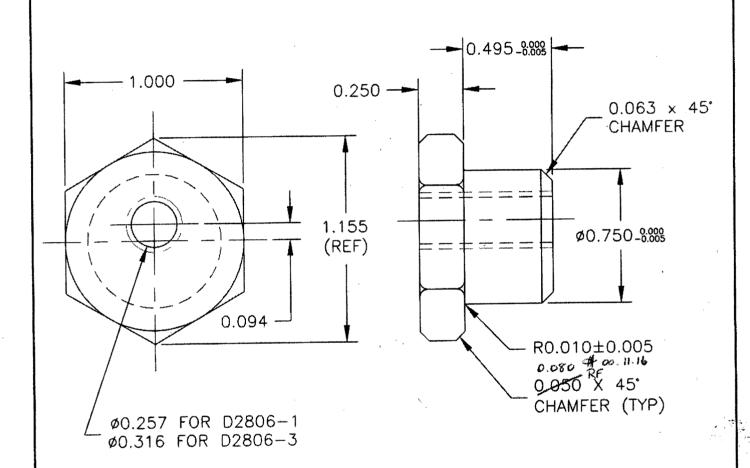
NCR:			WORK ORDE	ER NON-CONFORMAN	CE (NCR)			
		Description of NC		Corrective Action Section B			A	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspecto
							1	

NOTE: Date & initial all entries





	DESIG	#	ORAWN, BY	DART AEROSPACE LT HAWKESBURY, ONTARIO, CANADA	Ö
	CHECK	(ED	APPROVED	DRAWING NO.	REV. A
		P	I A	D2806 SH	EET 1 OF 1
	DATE	<u></u>	<u></u>	TITLE	SCALE
	00.1	1.08		BUSHING	2:1
*******	Α		00.11.08	NEW ISSUE	



D2806-1 (DRILL Ø0.257 HOLE) D2806-3 (DRILL Ø0.316 HOLE)

MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) OR (QQ-A-225/8) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1 BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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## Dart Aerospace Ltd

W/O:			٧	<b>VORK ORDER CHANGE</b>	S			
DATE	STEP	PROC	EDURE CI	HANGE	Ву	Date Qt	Approval Chief Eng / Prod Mgr	Approval QC inspector
								;
Part No	•	PAR #:	_ Fault Ca	tegory:	NCR: Yes	No DQA:	Date: _	
						/C Closed:	Date: _	
NCR:		W	ORK OR	DER NON-CONFORMAI	NEE (NCR	)		
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section Action Description Chief Eng	Sign & Date	Verificatio Section C	n Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	
Description: Bushing	Part Number:	D2806-3
Inspection Dwg: D2806 Rev: A	1	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.000	+/-0.010	1,006				
1.155	+/-0.010	1,150	_			
0.250	+/-0.010	1255				
0.063 x 45°	+/-0.010	.063×45°				
0.080 x 45°	+/-0.010	. 080 ×420	-			
0.495	+0.000/-0.005	,494				
0.750	+0.000/-0.005	,750				
Ø0.316	+0.005/-0.000	,317	~			
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						-
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Measured by: 06/06	119	Audited by:	MS	Prototype Approval:	N/A
Date:	i	Date:	06/10/19	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	04.02.25	New Issue	KJ/RF	